

# Work Order ID 84192

**\*84192\***

Page 1

May-07-12 11:21:07 AM

Item ID: D4149-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Crosstube Lug Assembly, Aft

Stop **\*NS2\***

Start Date: 07/05/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/07 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4149

C

100

0.00

**\*100\***

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location

0.00

**\*120\***

Packaging

Memo

0.00

Packaging

*bx*

*12/06/07*

*ST 468*

*(+6)*

*bx*

*SD 12-6-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 84192

\*84192\*

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Item ID: D4149-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Crosstube Lug Assembly, Aft

Start Date: 07/05/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
*130*									
QC	Memo	0.00							
Quality Control									

12/6/28 JH  
MF  
12-027

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

May-07-12 11:21:11 AM

Page 1

Work Order ID: 84192

\*84192\*

Parent Item: D4149-041

\*D4149-041\*

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 6.00

Required Qty: 6.00

## Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC  
IPP Rev:B 10.07.22 as per revB DD verf:JLM  
11.03.03 as per revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21043-3

Purchased

No

100

Each

1,001.000

4

12

\*MS21043-3\*

\*\*

Nut

### Location

### Loc Qty

### Loc Code

FG

72

103691

72

GA

88

120693

88

ST301

841

118077

2

118614

59

118686

30

119758

20

121255

730

MS21043-4

Purchased

No

100

Each

1,729.000

1

18

\*MS21043-4\*

\*\*

Nut

### Location

### Loc Qty

### Loc Code

FG

40

104603

40

ST301

1689

119546

201

121162

988

121652

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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May-07-12 11:21:11 AM

Page 2

Work Order ID: 84192

\*84192\*

Parent Item: D4149-041

\*D4149-041\*

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 6.00

Required Qty: 6.00

D3910-1 Manufactured No

\*D3910-1\*

Crosstube Lug

100 Each 41.0000 1 6

\*\*

Location

Loc Qty

Loc Code

st507

41

81474

2

81573

39

D4091-1 Manufactured No

\*D4091-1\*

Mounting Lug

100 Each 80.0000 1 6

\*\*

Location

Loc Qty

Loc Code

ST458

80

81168

30

81461

10

81575

40

D4149-1 Manufactured No

\*D4149-1\*

Crosstube Lug Plate, Aft

100 Each 15.0000 2 12

\*\*

Location

Loc Qty

Loc Code

ST133

15

82121

3

83472

12

D4149-3 Manufactured No

\*D4149-3\*

Spacer

100 Each 1.0000 1 6

\*\*

Location

Loc Qty

Loc Code

ST133

1

78046

1

May-07-12 11:21:11 AM

Shop Packet Print

Page 2

*Handwritten notes and signatures:*  
 - Multiple signatures across the right side of the page.  
 - "384194" written at the bottom right.  
 - "52" circled at the bottom right.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

May-07-12 11:21:11 AM

Page 3

Work Order ID: 84192

**\*84192\***

Parent Item: D4149-041

**\*D4149-041\***

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 6.00

Required Qty: 6.00

D4149-5 Manufactured No

100 Each

11.0000 1 6

**\*D4149-5\***

Eyebolt Stud

\*\*

Location

Loc Qty

Loc Code

ST133

11

83888

11

AN3C12A Purchased No

100 Each

247.0000 2 12

**\*AN3C12A\***

Bolts

\*\*

Location

Loc Qty

Loc Code

GA

40

120449

40

ST351

207

117514

4

118112

5

118451

22

119510

1

120423

125

121584

50

AN4C13A Purchased No

100 Each

78.0000 3 18

**\*AN4C13A\***

BOLT

\*\*

Location

Loc Qty

Loc Code

ST357

78

120187

1

120423

2

121444

50

121556

25

*EP 12/06/27*  
*384195*

*EP 12/06/27*

*EP 12/06/27*

*M122141*

*M121827*  
*15x*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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May-07-12 11:21:11 AM

Page 4

Work Order ID: 84192

**\*84192\***

Parent Item: D4149-041

**\*D4149-041\***

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 6.00

Required Qty: 6.00

MS20615-4M18

Purchased

No

100

Each

204.0000

3

18

**\*MS20615-4M18\***

Rivet

\*\*

*EP 12/06/27*

Location

Loc Qty

Loc Code

322

100

121349

100

ST322

50

121444

50

ST323

54

118543

54

*M122141 (18)*

NAS1149C0332R

Purchased

No

100

Each

4,550.000

4

24

**\*NAS1149C0332R\***

Washer

\*\*

*EP 12/06/27*

Location

Loc Qty

Loc Code

ST297

219

119736

196

120648

23

ST298

4331

121255

31

121509

4300

*M122063 (24)*

NAS1149C0432R

Purchased

No

100

Each

4,488.000

6

36

**\*NAS1149C0432R\***

Washer

\*\*

*EP 12/06/27*

Location

Loc Qty

Loc Code

ST297

1524

117291

524

119124

1000

ST298

2964

121255

2964

*36*

May-07-12 11:21:11 AM

Shop Packet Print

Page 4

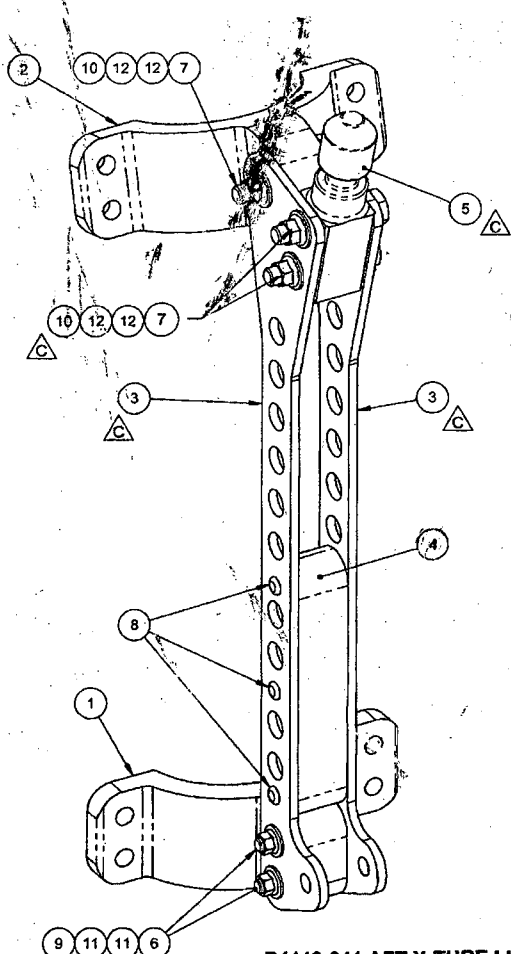
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**D4149-041 AFT X-TUBE LUG ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84192 MLJ  
12/05/07

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 2.21 lbs

RELEASED  
2011-02-24

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.257" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(5) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.128 3 PL (ZN D8-3). REASON: SEE TR-0350-007-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED, COPIED, OR OTHERWISE USED BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

AN4C13A BOLT  
NAS1149C0432R WASHER, 2X  
MS21043C4 NUT  
3PL

D4149-5  
EYEBOLT STUD

MS20615-4M18  
RIVET  
3 PL

**D4149-041 AFT X-TUBE LUG ASSY**

D4091-1  
MOUNTING LUG

D4149-1  
AFT X-TUBE LUG PLATE  
2 PL

D4149-3  
SPACER

AN3C12A BOLT  
NAS1149C0332R WASHER, 2X  
MS21043C3 NUT  
2 PL

D3910-1  
X-TUBE LUG

84192

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2011-02-24

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	A	DRAWING NO. <b>D4149</b>	REV. C
MFG. APPR.		SHEET 2 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		<b>AFT X-TUBE LUG ASSY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

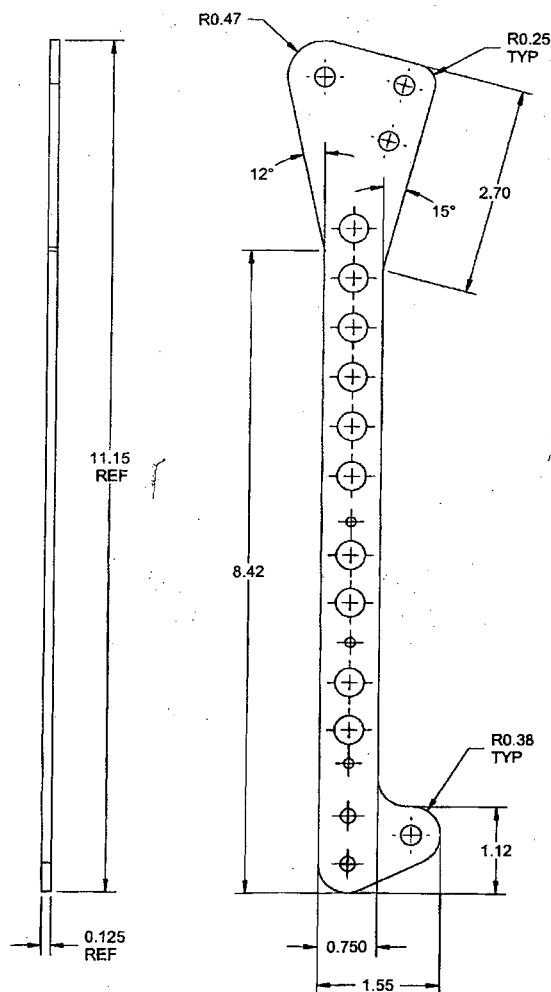
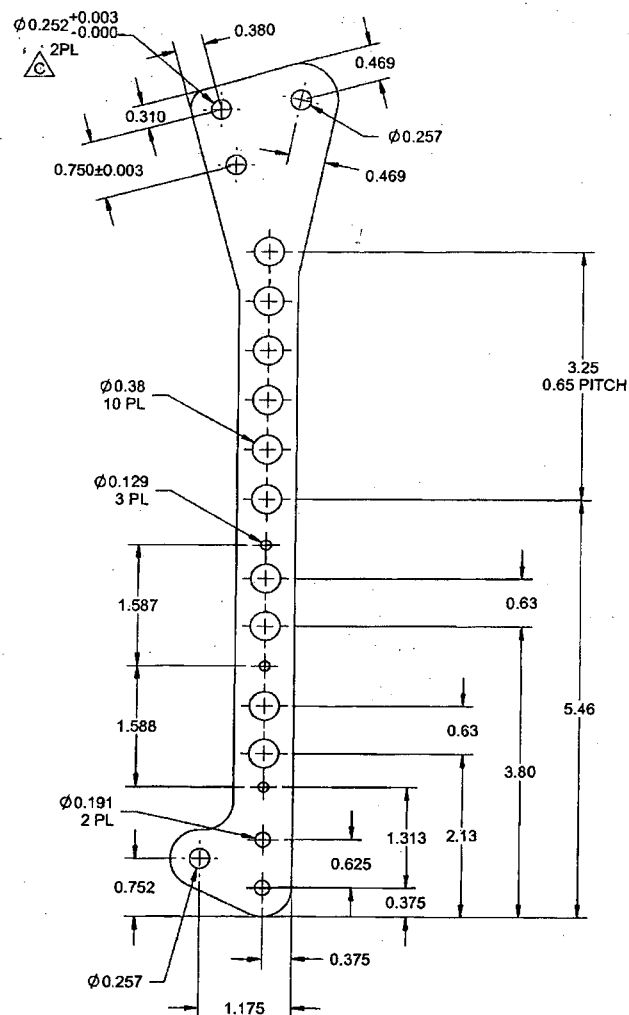
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**D4149-1 AFT X-TUBE LUG PLATE**

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET  
ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240  
OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.33 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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2011-02-24

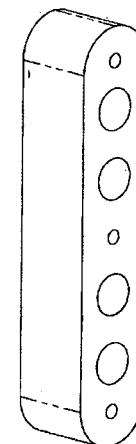
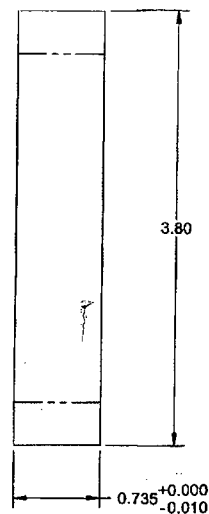
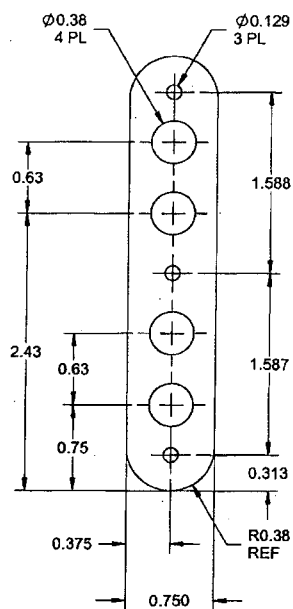
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**D4149-3 SPACER**

RELEASED  
2011-02-24

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582  
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESSBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. <b>D4149</b>	REV. C
MFG. APPR.		TITLE	SHEET 4 OF 5
APPROVED		<b>AFT X-TUBE LUG ASSY</b>	SCALE
DE APPR.			NTS
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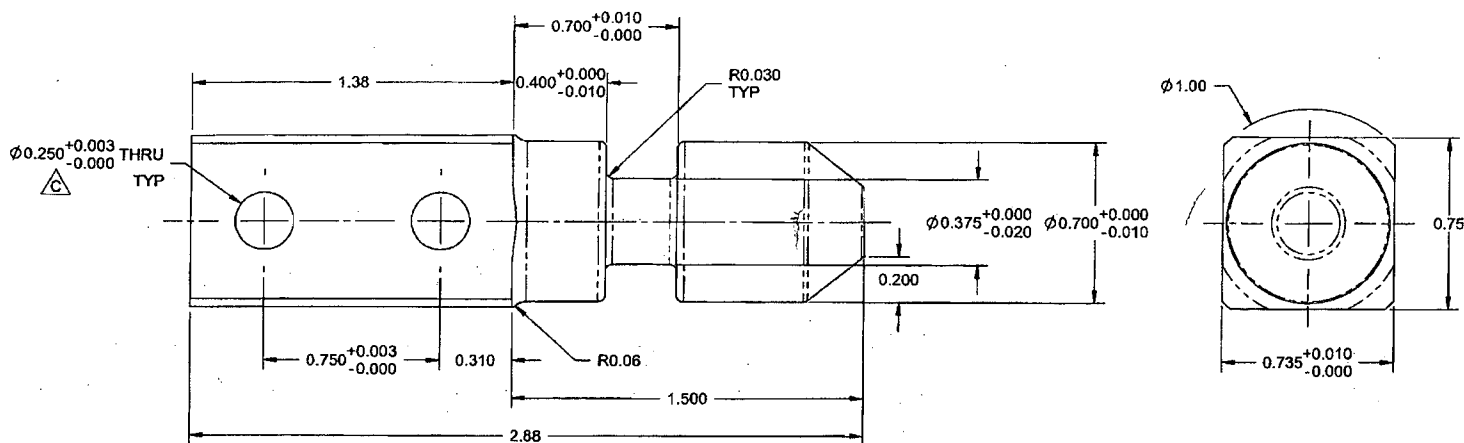
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**D4149-5 EYEBOLT STUD**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582  
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. <b>D4149</b>	REV. C
MFG. APPR.			SHEET 5 OF 5
APPROVED		TITLE <b>AFT X-TUBE LUG ASSY</b>	SCALE NTS
DE APPR.		<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	11.02.22		

**RELEASED**  
2011-02-24

84192

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries